Qty:

20 Um:

Each

: STOP

: D23243

: N/A

: C

. D2324 REV. C

: 05/06/2008

Date: User

Friday, 09/05/2008 1:45:20 PM

Julie Lecoca

Process Sheet

Drawing Name

Part Number

Material

Due Date

Description:

M107387

6061-T6 Bar .75" x .75"

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

: 39152A : 10731

P.O. Number

: 09/05/2008 This Issue

: NC Prsht Rev.

First Issue : //

Type : SMALL /MED FAB

: 36749A Previous Run

Written By Checked & Approved By

Comment

S.O. No. :

03.02.28

Reformat; Incorporated D2324-3 & D2324-5 K

: Est: J/RF

Additional Product

Job Number:



Seq. #:

1.0

2.0

3.0

Machine Or Operation:

M6061T6B0750X00750



Comment: Qty.:

0.5565 f(s)/Unit

Total: 11.1300 f(s)

6061-T6 Bar 0.75" x 0.75' Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)

(M6061T6B0.750x00.750)

BAND SAW

Batch: M 102476 × 10 065 BAND SAW



Comment: BAND SAW

_Cut_blanks: <u>(0.75" x 0.75") x 5</u>.75" Long Bar

HAAS CNC VERTICAL MACHINING #

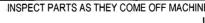


Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio D2324-3 and Dwg D2324

2- Deburr and Tumble to remove sharp edges Identify as D2324-3

4.0 QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK





Dart Aerospac	e	Ltd
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W/O:		4.4		WORK ORD	ER CHANGES					
DATE	STEP		PRO	OCEDURE CHANGE	17	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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•	X.					QA:	N/C Closed	l:	Date:	· · · · · · · · · · · · · · · · · · ·

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Se	Verification	Approval	T					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date '	Section C	Chief Eng	Approval QC Inspector			
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Date: Friday, 09/05/2008 1:45:21 PM Üser: Julie Lecocq **Process Sheet** Drawing Name: STOP 2 Customer: CU-DAR001 Dart Helicopters Services Job Number: 39152A Part Number: D23243 Job Number: Seq. #: **Machine Or Operation:** Description: HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 QC3 **Comment: INSPECT ALODINE** PACKAGING RESOURCE# 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	By Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
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	Description of NC		Corrective Action Section B	Verification	Approval	Approval	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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DART AEROSPACE LTD

Description: Strut

Part Number: D2324-3

Inspection Dwg: D2324 Rev: C

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+/-0.010	0,257				
Ø0.191	+/-0.010	\$ 194"				
0.750	+/-0.010	,753°				
0.375	+/-0.010	375"				•
1.875	+/-0.010	1,875"				
5.250	+/-0.010	5 249"				
5.625	+/-0.010	5,624"				7
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Measured by: J. F	Audited by:	Tol	Prototype Approval:	N/A
Date: 08/05//8	Date:	08/05/20	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.06.10	New Issue	P/O D2324-1	KJ/JLM ,	
В	06.03.08	Dwg Rev changed		KJ/JLM A	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: _	PAR #:	Fault Category:		NCR: Yes No	DQA:	Date: _	· · · · ·
			•	QA: N/C C	losed:	Date: _	

Verification Section C	Approval	Approval
	Chief Eng	QC Inspector
1		**
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	DESIGN B W	N ILLIAMS	DRAWN BY		_					LTD CANADA	
ı	CHECK		APPROVED.	DRAWING	NO.						REV. C
		#	-#	D2324					7	SHEET	1 OF 1
I	DATE		,	TITLE							SCALE
	04.1	2.14	÷	STRUT							
	Α	1-	94.11.08	NEW	ISSU	JΕ					
	В		96.05.07	UPDA	TE: N	MATE	RIALS	3			
	С		04.12.14	UPDA	TE N	NOTE	ES :				

D2324-5

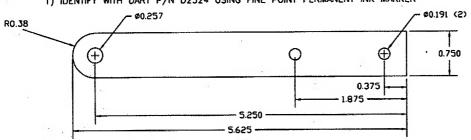
AN3-12A BOLT (1) AN960JD10 WASHER (2) MS21042L3 NUT (1) (TWO PLACES)

RELEASED 04.12.16

D2324-3

6.000(REF) 0 0

D2324 STRUT ASSEMBLY 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

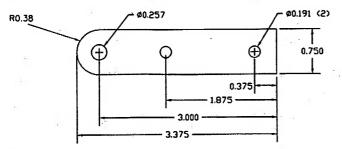
6061-T6/T651_BAR_(QQ=A=200/8)_0.75_X_0.75 1) MATERIAL: (REF DART SPEC. M6061T680.750X00.750)

ACID ETCH AND ALODINE PER DART QSI 005 4.1

2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)

(REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

Dart Aerospace Ltd

W/O:	-	WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	A.	-	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:	PAR #:	_ Fault Category: _	 	NCR: Yes No	DQA:	Date:	
•				QA: N/C	Closed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	A	A				
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